

# Work Order ID 69403

Tuesday, May 10, 2011 3:23:54 PM

Page 1

Item ID: K10003

Revision ID:

Item Name: Saddle, D205-634-011

Start Date: 5/10/2011 Start Qty: 4.00

Required Date: 5/16/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN634,635

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels only per PPP K10003

CHG 008

007

CLN 11-599

Sulzberg

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JJ for CL 11-07-13

JB 11/07/13

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sulzberg

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69403**

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Item ID: K10003

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, D205-634-011

Start Date: 5/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Identify as per dwg &amp; Stock Location:

Memo

0.00

0.00

140



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Quality Control

11/7/19 5/19

11/7/20

MF 11-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Work Order ID: 69403

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF  
IPP : J 06-07-25 As per DSI 9344 JLM  
IPP : K 06.11.17 Per K10003 Rev C KJ  
IPP : L 07.01.12 Document Record for copying bluefile rmv KJ  
IPP Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:  
IPP N 09.01.27 DSI 9418 rev B EC verified by: DD IPP Rev:O  
11.03.11 per dsi9536 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-51A

Purchased

No

110

Each

236.0000

8

32



Bolt

Location

Loc Qty

Loc Code

ST361

236

116003

36

117094

100

117313

50

117514

50

AN4-6A

Purchased

No

110

Each

1,159.000

16

164



Bolt

Location

Loc Qty

Loc Code

ST356

959

115936

159

116400

400

116924

400

ST358

200

117514

200

117794 x 18 B

117313 x 18

164

116400

11/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

Work Order ID: 69403

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

AN4C46A Purchased No

110 Each 253.0000

4

16



BOLT

Location

Loc Qty

Loc Code

ST360

253

107287

72

110823

181



107287x4  
110823x12

AN6-12A Purchased No

110 Each 171.0000

8

32



Bolt

Location

Loc Qty

Loc Code

ST342

171

116003

11

117094

100

117514

60



117514

AN960JD416 NAS1149D0463J Purchased No

110 Each 0.0000

32

128



Washer

AN960JD616 NAS1149D0663J Purchased No

110 Each 0.0000

8

32



Washer

D2570 Manufactured No

110 Each 162.0000

24

96



Bushing

Location

Loc Qty

Loc Code

ST017

162

66933

1

67759

161



117460x23 JB  
117591x106  
117291 JB  
68103x6 JB  
69814x32

11/07/13

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 69403

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

D2571  
Saddle, Fwd Out 205

Manufactured No

110 Each

13.0000



4 ✓  
70456x3 JB  
71552X1

*[Signature]*

Location

Loc Qty

Loc Code

ST433

13

63499

1

67664

12

D2572  
Saddle, Fwd In 205

Manufactured No

110 Each

11.0000



4 ✓  
71553 JB

*[Signature]*

Location

Loc Qty

Loc Code

ST433

11

67663

11

D2573  
Saddle, Aft Out 205

Manufactured No

110 Each

1.0000



4 ✓  
70458x1 JB  
71554

*[Signature]*

Location

Loc Qty

Loc Code

ST434

1

63501

1

D2574  
Saddle, Aft In 205

Manufactured No

110 Each

1.0000



4 ✓  
70409x1 JB  
71555x3

*[Signature]*

Location

Loc Qty

Loc Code

ST434

1

63502

1

D2747  
Set Screw

Manufactured No

110 Each

82.0000



4 ✓  
16  
69494 JB

11/07/13

Location

Loc Qty

Loc Code

ST021

82

64276

82

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 69403

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

D2876 Manufactured No

110 Each

78.0000

2 8 ✓



Saddle Spacer

Location

Loc Qty

Loc Code

ST025

30

66849

30

ST026

48

68282

48



JB

D2877 Manufactured No

110 Each

97.0000

2 8 ✓



Saddle Spacer

Location

Loc Qty

Loc Code

ST025

97

66843

37

68283

60



JB

D3405-041 Manufactured No

110 Each

4.0000

1 4 ✓



Lug Assembly

Location

Loc Qty

Loc Code

ST474

4

62227

2

62958

2



66843  
68283  
70820 JB

D3405-043 Manufactured No

110 Each

12.0000

1 4 ✓



Lug Assembly

Location

Loc Qty

Loc Code

ST423

2

65703

2

ST474

10

67970

10



6896619  
D31504  
11/07/13  
31  
5/10/11

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Work Order ID: 69403



Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

D3407-041

Manufactured No

110 Each

5.0000

1

4



Tow Ring



70981

JB

Location

Loc Qty

Loc Code

ST464

5

68749

5

D3417-5

Manufactured No

110 Each

55.0000

2

8



Washer



JB

Location

Loc Qty

Loc Code

ST053

55

67783

15

68972

40

D3456-1

Manufactured No

110 Each

77.0000

1

4



Washer



68972

71033

JB

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

70

66848

6

68748

64

D3533-1

Manufactured No

110 Each

112.0000

2

8



Set Screw



JB

11/07/13

Location

Loc Qty

Loc Code

ST066

112

66138

12

67583

100

67583

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 10, 2011 3:24:03 PM

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Work Order ID: 69403

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased No

110 Each

5,014.000

24

96



Nut

## Location

## Loc Qty

## Loc Code

ST300

5014

116823

1214

117441

3000

117601

800

117441

MS21043-4

Purchased No

110 Each

1,417.000

5

20



Nut

## Location

## Loc Qty

## Loc Code

FG

40

104603

40

ST300

600

117423

600

ST301

777

116188

-12

116549

289

117601

500

117601

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



REFERENCE ONLY

## 5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	*BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C47A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F

Date: 08.10.07

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. F AND  
INSTALLATION INSTRUCTIONS D204-635 REV. F

REF. TCCA STC SH96388

REF. FAA STC SR00563NY

REF. EASA STC EASA.IM.R.S.01303

**REFERENCE ONLY**

**PURPOSE:**

THE PARTS LIST OF INSTALLATION INSTRUCTIONS D205-634 REV. F AND D204-635 REV. F LISTS THE INCORRECT PART NUMBER FOR THE BOLT PROVIDED WITH D205-641-011 GROUND HANDLING KIT. THE CORRECT PART NUMBER FOR THE BOLT IS AN4C46A.

**CHANGE:**

THE PART NUMBER IN SECTION 5.0 OF D205-634 REV. F AND D204-635 REV. F AND SECTION 32.9 OF ICA-D204-635 REV. 3 IS AMENDED AS FOLLOWS:

**5.0 PARTS LIST (D205-634 REV. F)**

Item	634 -011	634 -015	634 -041	634 -045	641 -011	PART NUMBER	DESCRIPTION
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT

**IS:**

52					4	AN4C46A	BOLT
----	--	--	--	--	---	---------	------

**WAS:**

52					4	AN4C47A	BOLT
----	--	--	--	--	---	---------	------

**5.0 PARTS LIST (D204-635 REV. F)**

**32.9 PARTS LIST (ICA-D204-635 REV. 3)**

Item	635 -011	635 -041	641 -011	PART NUMBER	DESCRIPTION
	X			D204-635-011	SKIDTUBE INSTALLATION
	1	X		D204-635-041	SKIDTUBE
	1		X	D205-641-011	GROUND HANDLING KIT

**IS:**

52			4	AN4C46A	BOLT
----	--	--	---	---------	------

**WAS:**

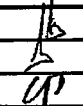
52			4	AN4C47A	BOLT
----	--	--	---	---------	------

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY:   
D. SHEPHERD (DE # 02)

DATE: 10.11.26  
CERT. NO.: SH96-88  
ISSUE NO.: 3

A	NEW ISSUE (REF. CAR10-27)	MB	10.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	 <b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	DRAWING NO. REV. A	
DRAWN		DSI 9536 SHEET 1 OF 1	
CHECKED		TITLE SCALE	
MFG. APPR.		P/N CORRECTION NTS	
APPROVED		DATE 10.11.26	
DE APPR.	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		